

Date: Friday, 9/14/2007 9:13:00 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR
Job Number	: 34606		
Estimate Number	: 10766		
P.O. Number	: N/A	Part Number	: D32453
This Issue	: 9/14/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3245 REV A
First Issue	: 9/12/2007	Project Number	: N/A
Previous Run	: 23887	Drawing Revision	: A
		Type	: PURCHASED PARTS
		Material	: N/A
		Due Date	: 10/5/2007
Written By	: <i>[Signature]</i> 07-09-14	Qty:	8 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A 04.07.07 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0 M304S22GA

304/316 .032 Sheet



Comment: Qty.: 0.5370 sf(s)/Unit Total: 4.2960 sf(s)

304/316 .032 Sheet

BATCH: 105262

1807-09-18

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: A

Prog Rev: A

1807-09-18

(8)

2-Deburr if necessary

1807-09-18

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



1807-09-18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

52/09/19

(X8)

counted

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr if necessary, buff entire surface to ensure a nice surface finish.

Form D3245-3 as per Dwg D3245

Identify as D3245-3

SB 07/11/19

(8)

[Handwritten signatures and notes]

52

Date: Friday, 9/14/2007 9:13:00 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 34606

Part Number: D32453

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6/11/13 (x8) counter

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 183

6/11/20 (8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

6/11/20

Job Completion

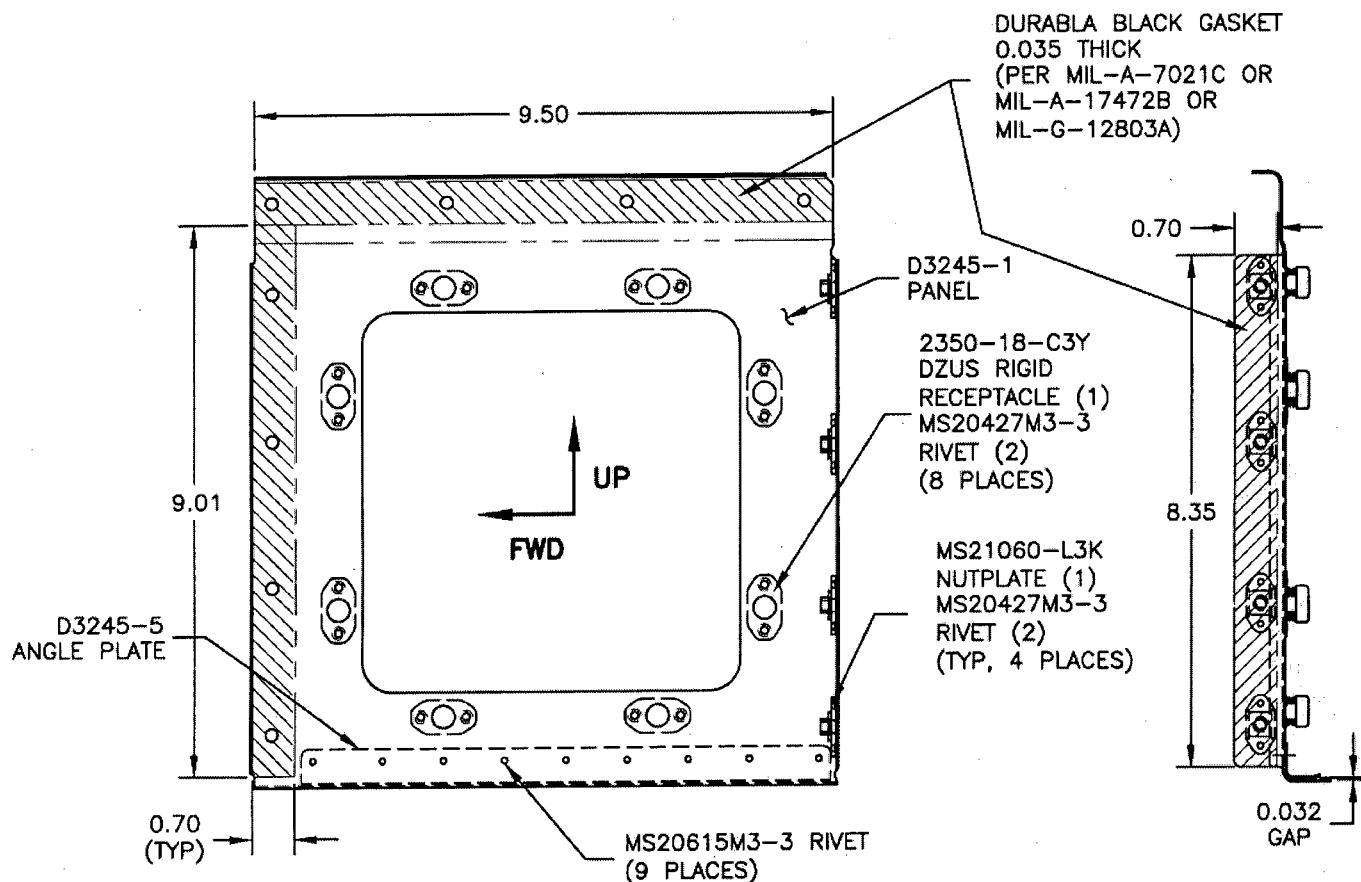


6/11/20



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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3
A	04.01.27	NEW ISSUE	

RELEASED
04.04.21 H



D3245-041 ACCESS PANEL ASSEMBLY

D3245-041 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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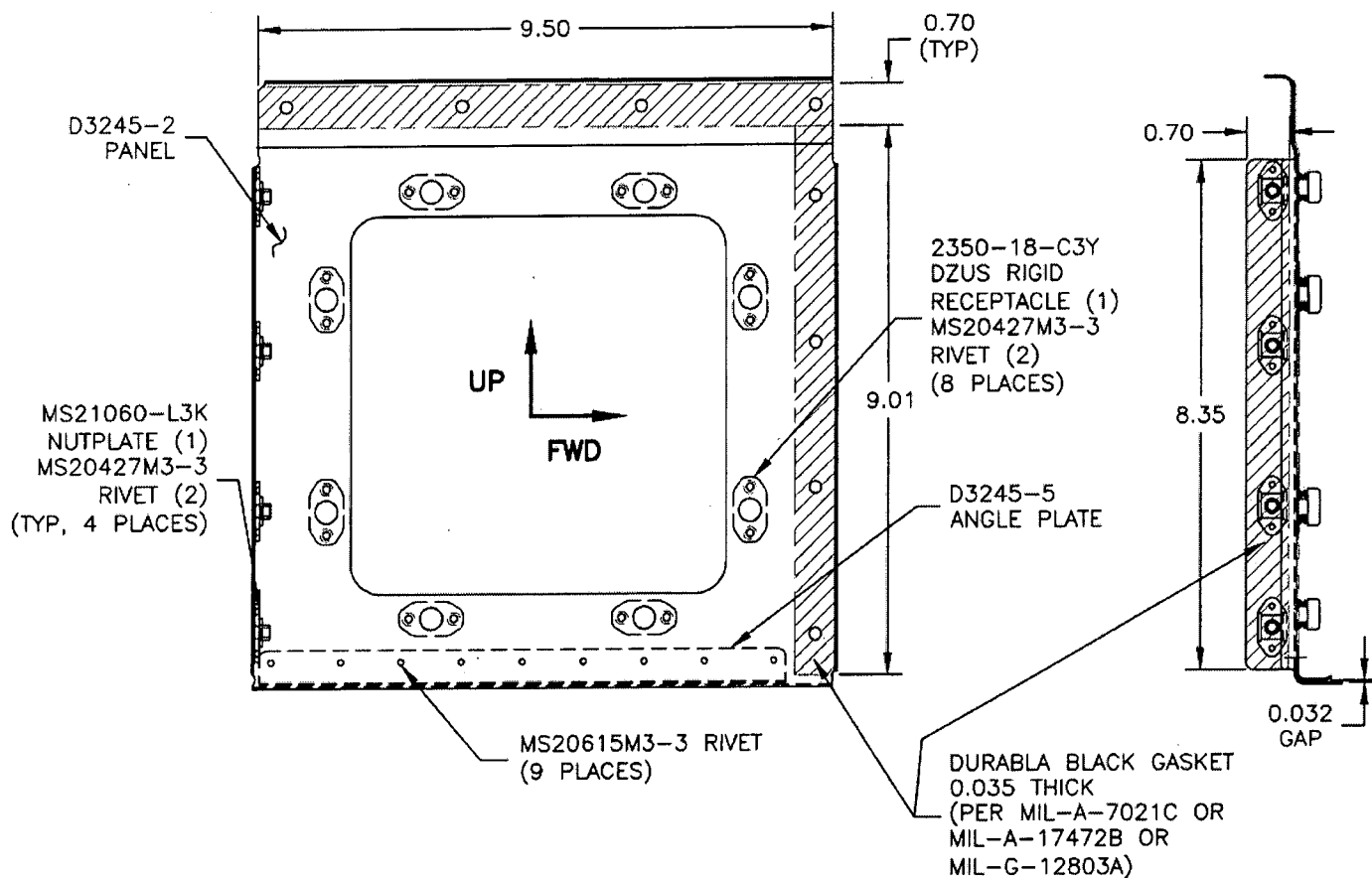
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04.01.27



D3245-042 ACCESS PANEL ASSEMBLY

D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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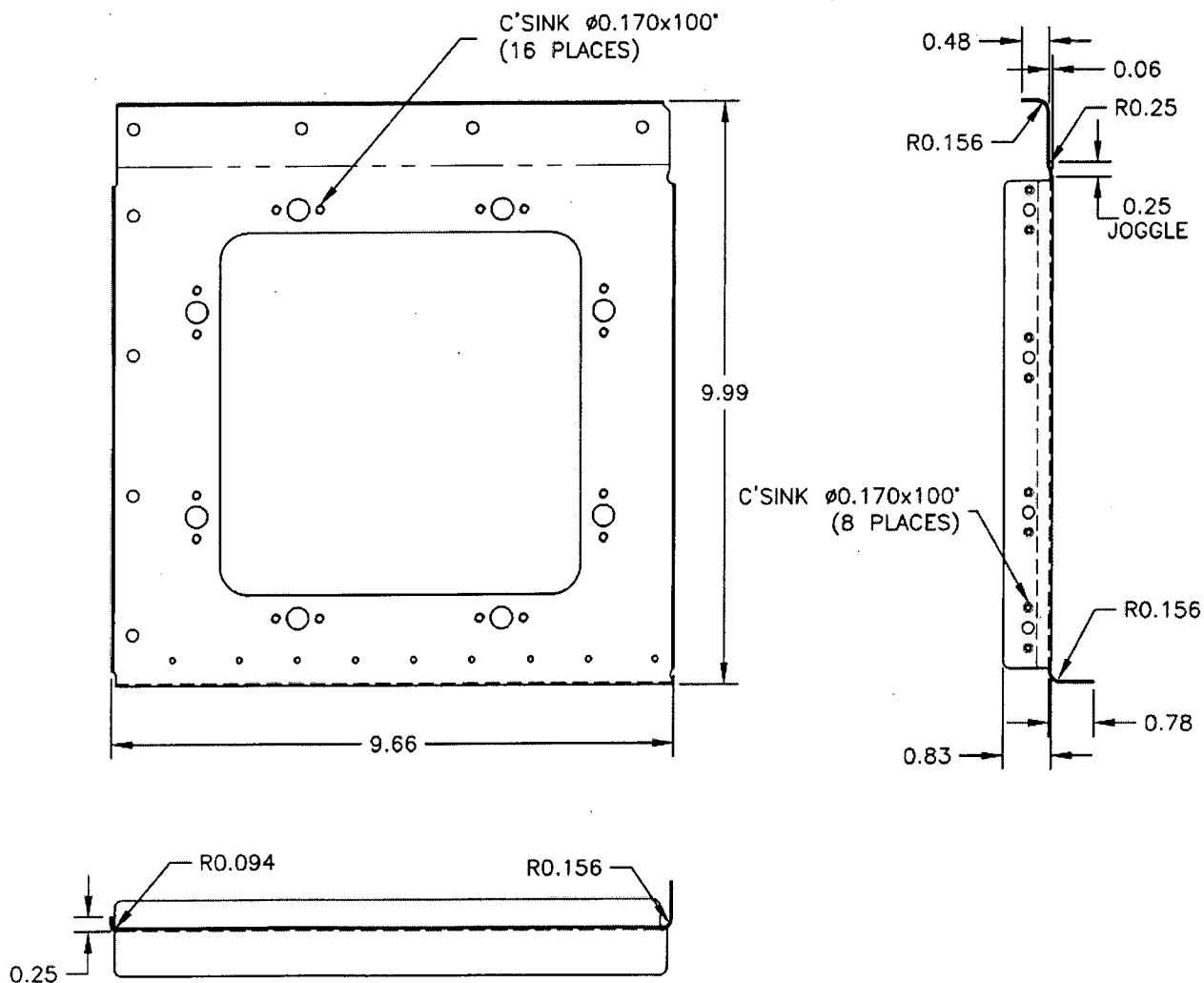
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3

RELEASED
04.04.21 *H*



**D3245-1 PANEL BEND DETAIL SHOWN
BEND D3245-2 PANEL OPPOSITE**

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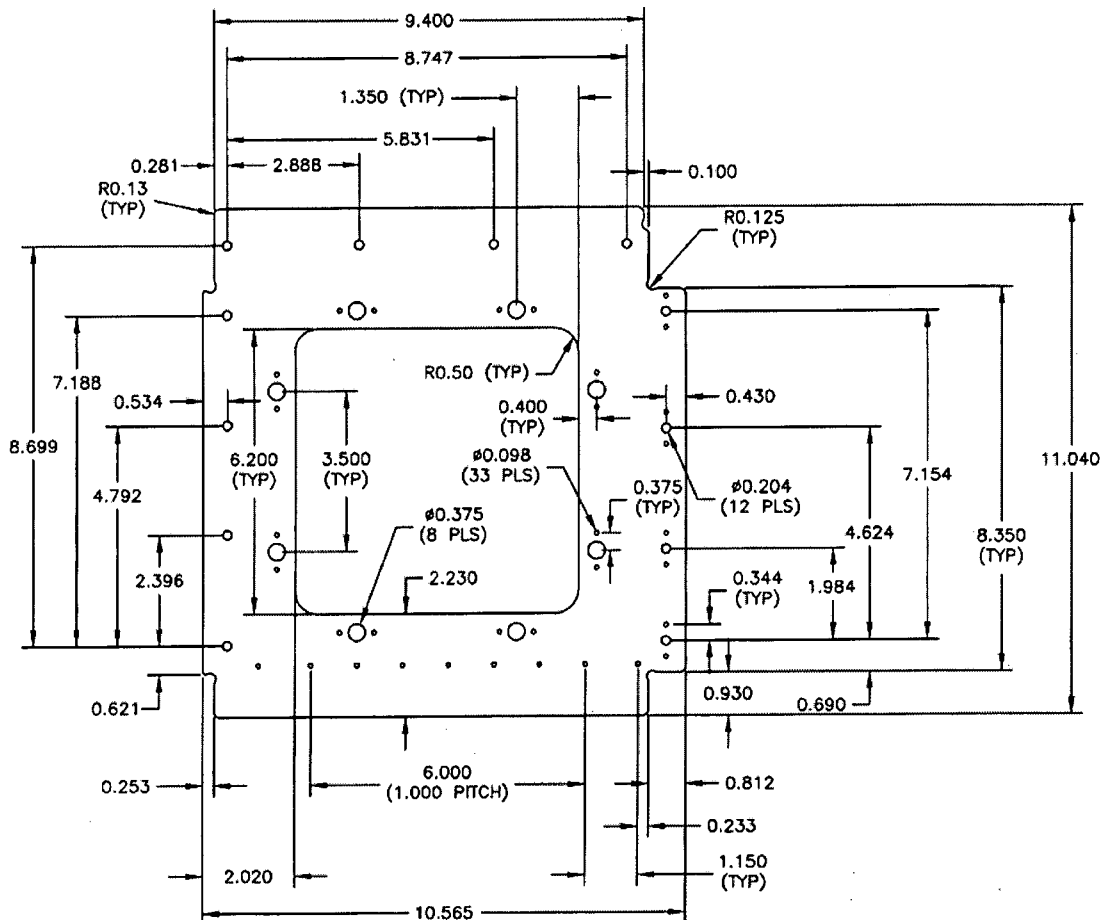
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.21 *[Signature]*



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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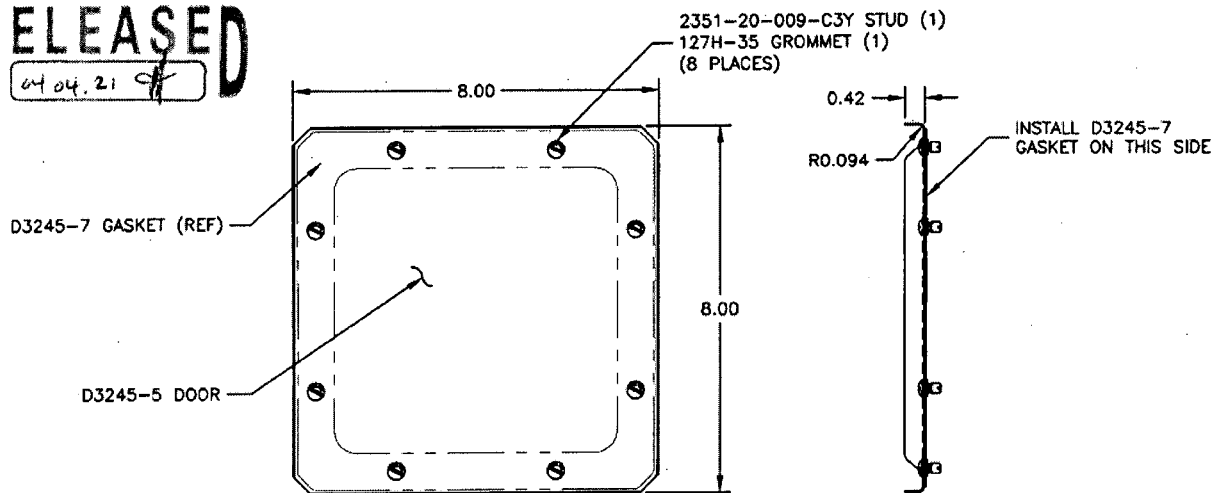
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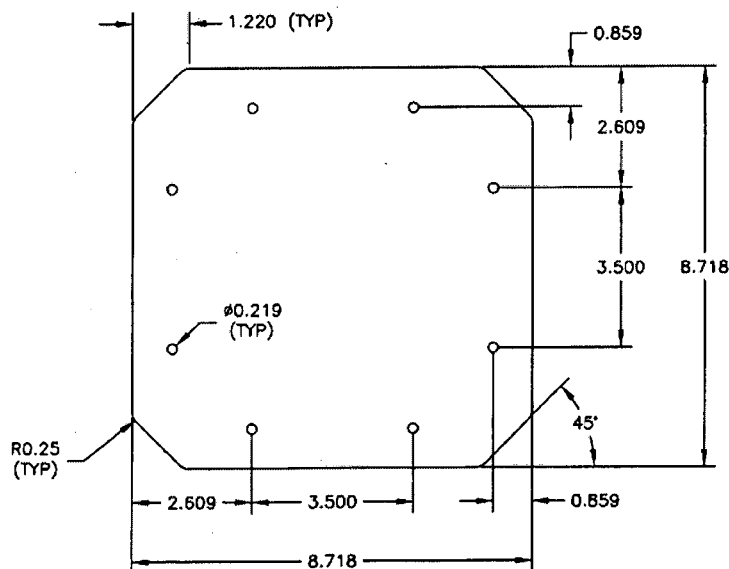


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04.04.21

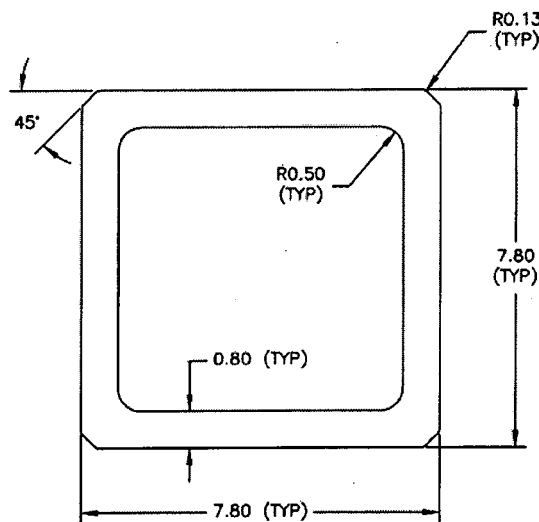


D3245-043 DOOR ASSEMBLY



D3245-3 DOOR FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.032 THICK
ANNEALED (REF. M304S22GA)



D3245-7 GASKET

MATERIAL: DURABLE BLACK GASKET 0.035 THICK
(PER. MIL-A-7021C OR MIL-A-17472B
OR MIL-G-12803A)

D3245-043 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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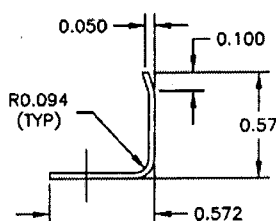
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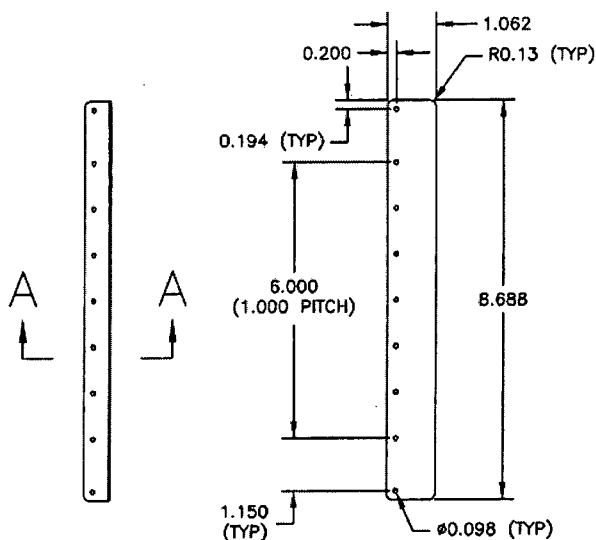


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04.04.05 H



D3245-5 BEND DETAIL
VIEW A-A
SCALE 1:1



D3245-5 FLAT PATTERN

D3245-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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